Work Order ID 71794 Tuesday, July 12, 2011 9:51:06 A								-		Page 1
Item ID: D3508-13 Revision ID:		A	ccept				s s	etup Start	1 12 8 11 6 1 6 1 8 1 8	
	tart Qty: 12.00 deq'd Qty: 12.00			Cust Item Customer:	ID:			Stop		
Approvals: Process Plan: QC:	W	Date://-08-//	Tooling: SPC (Y/N):		ate:		R	tun Start Stop		
	peration escription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr Revisio	on Nbr						·		· · · · · · · · · · · · · · · · · · ·	
D3508 Rev C										
100 FL Waterjet	LOW, WATER JET Memo		0.00	:			BIL	-7-17		
FLOW CNC Waterjet 3d1 - CL(O	1-Cut as per E Deburr if nece	owg D3508 □Dwg Rev:_ essary	□Prog Rev:_	<u> </u>			-		C	
110 QC	C2- Inspect parts off mad	chine FAI/FAIB	0.00				.			
QC Quality Control	Memo		0.00	,			<u>+13</u>	11 <u>-7-1</u> 2		

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

Dail Ac	ospace	Liu								
W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							•			
·										
			;							
Part No		PAR #:								
	R	esolution:	Disposition	n:	QA:	N/C Cld	osed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC			tion B	Ciam 0	Verific		Approval	Approval
	J	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
									·	
										·

Work Order ID 71794

Tuesday, July 12, 2011 9:51:06 AM



Page 2

Item ID:

D3508-13

Accept

Setup Start



Revision ID:

Item Name:

Required Date: 7/18/2011

Wearplate

7/12/2011

Start Otv: 12.00 Reg'd Otv: 12.00

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Sequence ID/

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Stop



Date: ____

SPC (Y/N):

Set Up/

Run Hours

Date:

Code

Tool # Plan

Accept Reject Otv

Reject Number

Insp. Stamp

Work Center ID 130

Brake NC Brake NC

NC BRAKE

Operation

Description

Memo

0.00

0.00

1-Form on brake using DT8326 and DT8261as per Dwg D3508 S 1167 35

Tool ID

Otv

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

Memo

0.00

150

Large Fab

Large Fab

0.00

Large Fab

Weld hardcoat as per dwg D3508 QSI004 Hardcoat 2059b Batch: M//845 3

E 11-8-5

Dart Act	Ospace	5 Liu						5	Nº 4
W/O:			WO	RK ORDER CHANGE	ES				1
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						·			
Part No		PAR #:	Fault Cated	lory:	NCB: Vas	No DO		Date:	
		esolution:							
NCR:		1900		R NON-CONFORMA					
		Description of NC	,	Corrective Action Section	Verit			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector
								·	
							٠		

Work Order ID 71794

Tuesday, July 12, 2011 9:51:06 AM



Page 3

Item ID:

D3508-13

Accept

Setup Start

Stop



Revision ID:

Item Name:

Wearplate

Start Date:

7/12/2011

Required Date: 7/18/2011

OC:

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

0.00

Tooling: SPC (Y/N):

Date: Date: Run

Start Stop

Sequence ID/

Work Center ID

160

Quality Control

Operation Description

OC10- Inspect visual per OSI004- ground welds

Set Up/

Run Hours

Tool ID

Tool # Plan Code

Accept Oty

Reject Oty

Reject Insp. Number Stamp

QC5- Inspect part completeness to step on W/O

0.00

170

Quality Control

Memo

Memo

180

Powdercoat Powder Coating Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

11117378

Memo

0.00

0.00

START TIME:

7: 1-a OVEN TEMPERATURE:

ラント 「ACOFINISH TIME:

12 \$ Mulodo 8

	Johnson								
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	1;	_ QA: N/C C	losed:		Date: _	
NCR:		1	WORK ORDE	R NON-CONFORMA	NCE (NCI	₹)			
DATE	STEP	Description of NC	Corrective Action Section B			Verific	cation	Approval	Approval
	OIL!	Section A	Initial Chief Eng	Action Description Chief Eng	Sign o		ion C	Chief Eng	QC Inspector
		·	,						
		,							
					:				
								:	

Work Order ID 71794

Tuesday, July 12, 2011 9:51:06 AM



Page 4

Item ID:

D3508-13

Accept



Setup Start



Revision ID:

Item Name:

Wearplate

Start Date: 7/12/2011

Required Date: 7/18/2011

Start Oty: 12.00

Req'd Oty: 12.00



Cust Item ID: Customer:

Reference:

Approvals:

OC:

Process Plan:

Date: Date:

Tooling: SPC (Y/N): Date:

Date:

Run

Start

Stop



Sequence ID/

Work Center ID

190

Quality Control

Operation Description

OC3- Inspect Part Finish

Memo

Set Up/ Run Hours

0.00

0.00

Tool ID

Tool # Plan Code

Accept Otv

Reject Otv

Reject Number

Insp. Stamp

Identify as per dwg & Stock Location: FP \ C



Memo

0.00

X12 & M 1/0-3/08

210

200

Packaging

Packaging

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

D uit 70	oopaoc	Liu							
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
	Re	esolution:	Disposition	n:	_ QA: N/C C	losed:		Date:	
NCR:	,	,	WORK ORD	ER NON-CONFORMA	ANCE (NCF	(3)			
DATE	STEP	Description of NC	C Corrective Action Section			Verific	cation	Approval	Approval
DAIL	SILP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
		,							
_									

Picklist Print

Tuesday, July 12, 2011 9:51:13 AM

Work Order ID: 71794

Parent Item:

D3508-13

Parent Item Name: Wearplate



Start Date: 7/12/2011

Required Date: 7/18/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 07.06.12

IPP Rev:B Rev C dwg 07-12-06 DD

EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	115.0630	0.172	2.172632			
										B	11-7-1	2	

304/316 .040 Sheet

<u>Location</u>	Loc Qty	Loc Code
MAT020	115.063	
116623	0.2	
117550	9.363	
117933	105.5	



Dait Aci	оориос									
W/O:			W	ORK ORDER CHANGE	ES			*	1 21	
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	1	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							A Territoria			
Part No	•	PAR #:	Fault Cat	egory:	NCR: Y	es No	DQ.	A:	_ Date: _	
	R	esolution:	Dispositi	on:	QA: N/C	Clos	ed:		Date: _	
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sig	ın & ate	Verific Secti		Approval Chief Eng	Approval QC Inspector
						-				
									· · · · · · · · · · · · · · · · · · ·	

DART AEROSPACE LTD	Work Order:	11794
Description: Wearplate	Part Number:	D3508-13
Inspection Dwg: D3508 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.38	+/-0.030	8.382	7		PROUZO2	
5.625	+/-0.010	5,676	8		W (BOZ	
0.375	+/-0.010	,375	H		V	
2.813	+/-0.010	2.810	7		V	
2.063	+/-0.010	2,066	5		V	
Ø0.187	+0.005/-0.001	, 191	7		V	
0.300	+/-0.010	1303	200		V	
0.300	+/-0.010	305	V			
					, .	

Measured by:	B	Audited by:	MM	Prototype Approval:	N/A
Date:	(1-7-17)	Date:	11.07.12	Date:	N/A

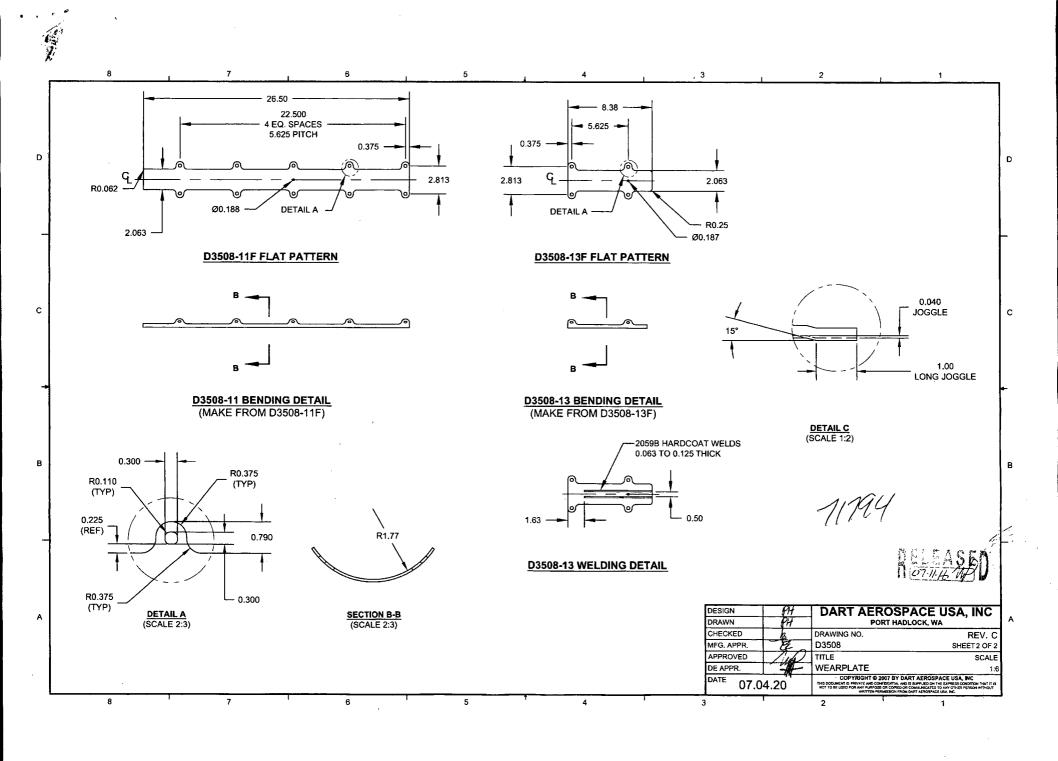
Rev	Date	Change	Revised by	Approved
Α	08.01.23	New Issue	KJ/EC/DD	

Duit Aci	ospace	FLICE								
W/O:			WC	ORK ORDER CHANG	GES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:		PAR #:	Fault Category: NC			s No DQ	A:	Date:		
Resolution:			Disposition: Q/			QA: N/C Closed:			Date:	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NO	R)				
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verificati		n Approval	Approval	
DAIL	J.L.		Initial Chief Eng	Action Description Chief Eng	Sigr Da		tion C	Chief Eng	QC Inspector	
~										
		·								
,		·								

IINCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER - 37.13 31.62 28,125 33.750 5 EQ. SPACES 6 FO SPACES 5.625 PITCH 5.625 PITCH DETAIL A 0.375 -5.800 0.375 DETAIL A DETAIL A - 2.063 (TYP) D 2.813 2.813 0.375 (TYP) Ø0.188 2.063 R0.063 Ø0.188 (TYP 2 PLACES) R0.062 Ø10 188 2.063 (TYP 2 PLACES) 2.813 **D3508-5 FLAT PATTERN D3508-1 FLAT PATTERN D3508-3 FLAT PATTERN** С R30.0 DETAIL C **D3508-1 BENDING DETAIL D3508-3 BENDING DETAIL D3508-5 BENDING DETAIL** (MAKE FROM D3508-1F) (MAKE FROM D3508-5F) (MAKE FROM D3508-3F) 16.10 NOTES: 13.750 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) 17.400 (REF. DART MATERIAL SPEC M304S20GA) 6.875 0.375 POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 2) FINISH: (TYP) 3) WELD PER DART OSI 004 - 0.375 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED R0.062 5) UNITS: INCHES UNLESS OTHERWISE NOTED 6) BREAK SHARP EDGES: 0.005 TO 0.015 2.813 2.813 7) IDENTIFICATION: NONE D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs, 8) WEIGHT: DETAIL A D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs DETAIL 2.063 D3508-13 - 0.25 lbs 2.063 - 2.90 Ø0.188 Ø0.188 ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT 07.04.20 **D3508-7F FLAT PATTERN D3508-9F FLAT PATTERN** CHANGE STAINLESS STEEL WIDEN PH 06,10,27 В NEW ISSUE PH 06.04.21 Α DESCRIPTION BY DATE REV. DART AEROSPACE USA, INC DESIGN DRAWN R30.0 CHECKED DRAWING NO. REV. C MFG. APPR. D3508 SHEET 1 OF 2 APPROVED TITLE SCALE D3508-9F BENDING DETAIL **D3508-7F BENDING DETAIL** WEARPLATE DE APPR. (MAKE FROM D3508-7F) (MAKE FROM D3508-9F) COPYRIGHT @ 2007 BY DART AEROSPACE USA, INC DATE 07.04.20

RETURN TO FINGINEERING

W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	CEDURE CHA	NGE	By Date Qty			Approvai Chief Eng / Prod Mgr	Approval QC Inspector		
						:					
			·····								
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ /	A:	_ Date: _			
			Disposition: QA: N/C Closed:								
NCR:		1	WORK ORD	ER NON-CONFORMA	NCE (NCR)					
DATE	OTED	Description of NC Section A	Corrective Action Section B			Verification		Approval	Approval		
	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector		
					ŀ						
						i C			·		



Dail Aci	ospace	Ltd							-
W/O:		· · · · · · · · · · · · · · · · · · ·	W	ORK ORDER CHANG	ES				•
DATE STEP		PRO	CEDURE CH	ANGE	By Date Qty Approval Chief Eng / Prod Mgr QC In				Approval QC Inspector
		**	A						
Part No	•	PAR #:	Fault Cat	legory:®-	NCR: Yes	No DQ	A :	Date:	
					QA: N/C Closed: Date:				
NCR:		\	WORK ORI	DER NON-CONFORMA	NCE (NC	R)	<u> </u>		
DATE	0.750	Description of NC Section A Corrective Action Section Initial Action Description Chief Eng Chief Eng				Verific	Verification	Approval	Approval
DATE	STEP		Sign Date	& Secti	Section C C		QC Inspector		
				Marin.					
			-a,196.						
							•		
		·							